

Date: Wednesday, 16/04/2008 3:53:29 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 38640		
Estimate Number	: 11168		
P.O. Number	:	Part Number	: D22823
This Issue	: 16/04/2008	S.O. No.	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 35472	Material	:
Written By	:	Due Date	: 09/05/2008
Checked & Approved By	: ST2D 08.4.16	Qty:	40
Comment	: Est Rev:A	Removed from 9 Digit	05-12-02 JLM
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0675W091	304 RD Tube .675 x .091W	
Comment:	Qty.: 0.2078 f(s)/Unit Total : 8.3118 f(s)		
Material:	T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness		
(M304TR0.675W.091)			
Batch	<u>M105322</u>	<u>MMF 08/04/23</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
Comment:	HARDINGE CNC LATHE SMALL		
1-Turn	as per Dwg D2282 and Folio FA188		
2-Deburr	<u>JF/08/23</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<u>JF off</u>	
4.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK	<u>MMF 08/04/23</u>	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment:	PACKAGING RESOURCE #1	<u>8/4/23</u>	
Identify and Stock			
Location:	<u>WS</u>	<u>SP</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/04/2008 3:53:30 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 38640

Part Number: D22823

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38640
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

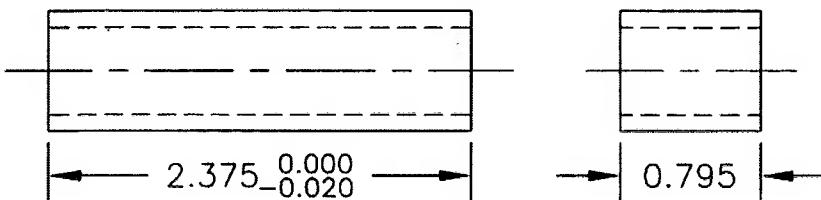
Measured by:	MMF/SPK	Audited by:	RQ	Prototype Approval:	N/A
Date:	08/04/23	Date:	08/04/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Tolerance changed	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	<i>[Signature]</i>

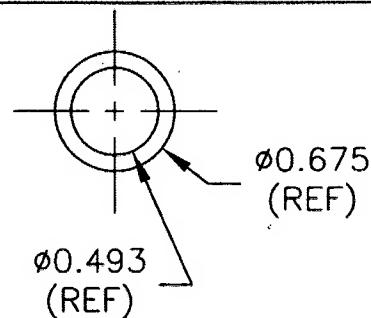
DART

DESIGN BW	DRAWN BY <i>FZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

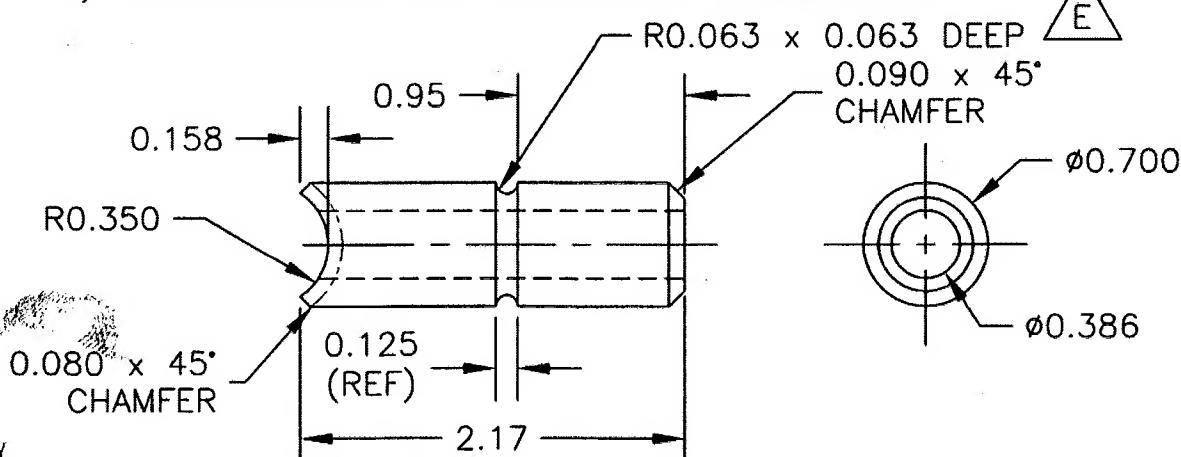
RELEASED
RE-DESIGN
05/09/16

**D2282-3**

D **D2282-7**

**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D **D2282-5**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 38670

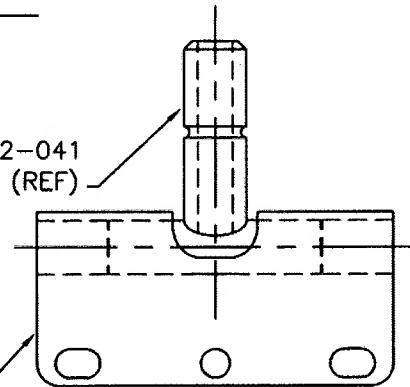
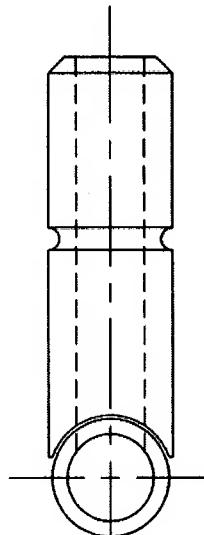
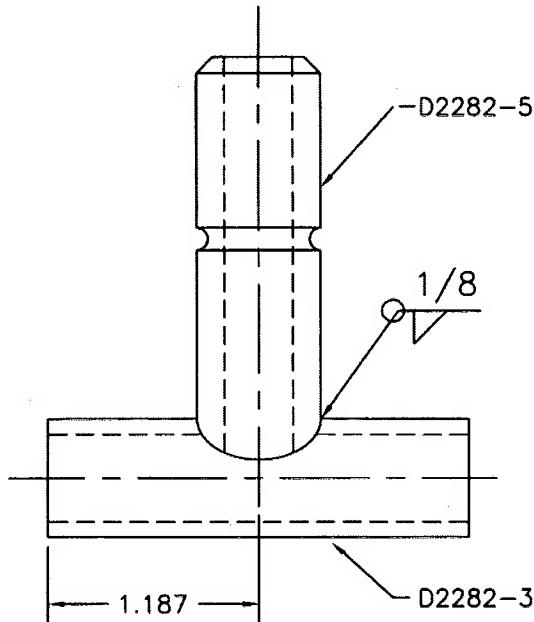
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

DART

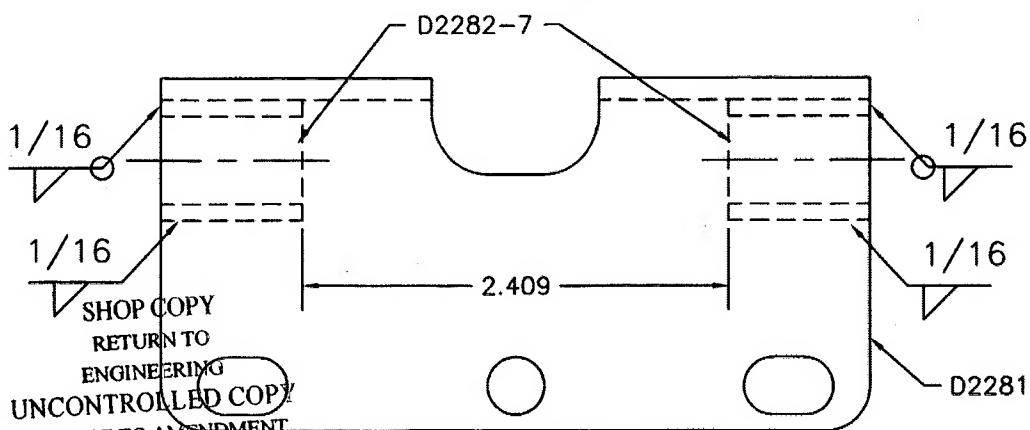
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



WITHOUT NOTICE
WORK ORDER **D2282-043 SADDLE ASSEMBLY**
NO. 381640 WELD ASSEMBLY PER DART QSI 004

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